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**(54)METHOD OF CLADDING FOR VALVE SATE  
IN CYLINDER HEAD**

**(57)Abstract:**

**PURPOSE:** To prevent generation of flaws such as underfill, attenuation of base material and cracks.

**CONSTITUTION:** A waste thickness part 7, 8 continuous to a seat surface 2a is projectingly formed preliminarily, on both ends in the groove width direction of a seat surface 2a which is in the shape of a groove with a circular-arc cross section. Consequently, the holding capacity of a powder 5 is increased on the seat surface 2a, and heat capacity is also increased at both ends in the groove width direction of the seat surface 2a. After a cladding layer 6 is formed, cutting is performed so that the valve seat 2 is finished into the final machined

shape 2b with the extra thickness part 7, 8 cut and removed simultaneously.

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